

Work Order ID 136355

Thursday, October 01, 2015 3:05:29 PM

136355

Page 1

Item ID: D500-572-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 8/20/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/1/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: OCT 01 2015

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2435

Rev E1

IIND500-572

RevA

DAS
27
9-89

100

Document Control

0.00

DAS
38
9-89

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D500-572-011 CHG005

2

15-10-05

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

DAS
27
9-89

27

OCT 05 2015

38

Picklist Print

Thursday, October 01, 2015 3:05:33 PM

Page 1

Work Order ID: 136355

136355

Parent Item: D500-572-011

D500-572-011

Parent Item Name: Bearpaw

Start Date: 8/20/2015

Required Date: 9/1/2015

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:C04.02.17Blank size changedKJ/JLM

IPP Rev:D 07-01-02 Was K10007 JLM

IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC

IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
QS200-M44S *QS200-M44S* CLAMP	DAS 38 9-89	Purchased	No			120	Each	22.0000	2	4			DAS 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST545		22							
				m131340		22				4			
AN4-15A *AN4-15A* Bolt	DAS 38 9-89	Purchased	No			170	Each	228.0000	8	16			DAS 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		40							
				120449		40							
				ST325A		100							
				m132551		0							
				m133284		100							
				ST343		88							
				m132551		88				16			
D2182B *D2182B* Rubber Cushion - Black (\$Per Foot)	DAS 38 9-89	Manufactured	No			170	f	633.2603	1.666	3.332			DAS 27 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST411		633.2603							
				130427		283.2603				3.332			
				135093		350							

4X5" per kit

OCT 05 2015

Picklist Print

Thursday, October 01, 2015 3:05:33 PM

Page 2

Work Order ID: 136355

136355

Parent Item: D500-572-011

D500-572-011

Parent Item Name: Bearpaw

Start Date: 8/20/2015

Required Date: 9/1/2015

Start Qty: 2.00

Required Qty: 2.00

D2274

Manufactured No

170

Each

76.0000

8

16

D2274

Radius Block

DAS

38

9-89

**

DAS

27

9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

64

134217

64

D2435

Manufactured No

170

Each

8.0000

2

4

D2435

Bearpaw

DAS

38

9-89

**

DAS

27

9-89

Location

Loc Qty

Loc Code

PKG

4

128312

4

ST446A

4

131059

2

135548

2

D2438

Manufactured No

170

Each

80.0000

4

8

D2438

Clamp

DAS

38

9-89

**

DAS

27

9-89

Location

Loc Qty

Loc Code

ST

6

110276

6

ST542

74

128921

24

131052

50

Thursday, October 01, 2015 3:05:33 PM

Shop Packet Print

Page 2

Picklist Print

Thursday, October 01, 2015 3:05:33 PM

Page 3

Work Order ID: 136355

Parent Item: D500-572-011

Parent Item Name: Bearpaw

136355

D500-572-011

Start Date: 8/20/2015

Required Date: 9/1/2015

Start Qty: 2.00

Required Qty: 2.00

D2529 Manufactured No 170 Each 299.0000 8 16

D2529

Washer

DAS
38
9-89

DAS
27
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST007

99

131945

99

ST008

200

135846

100

136774

100

76

MS21042L4

Purchased

No

170

Each

1,420.000

8

16

MS21042L4

Locknut

DAS
38
9-89

DAS
27
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

112

m127813

112

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

1136

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

956

16

OCT 05 2015

Thursday, October 01, 2015 3:05:33 PM

Shop Packet Print

Page 3

Picklist Print

Thursday, October 01, 2015 3:05:33 PM

Page 4

Work Order ID: 136355

136355

Parent Item: D500-572-011

D500-572-011

Parent Item Name: Bearpaw

Start Date: 8/20/2015

Required Date: 9/1/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

170

Each

4,495.000

8

16

NAS1149D0463.J

WASHER

DAS
38
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

2000

M133284

2000

ST269

2454

M129682

86

M130799

371

M132317

125

M132677

888

M133077

984

DAS
27
9-89

OCT 05 2015

Thursday, October 01, 2015 3:05:33 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____

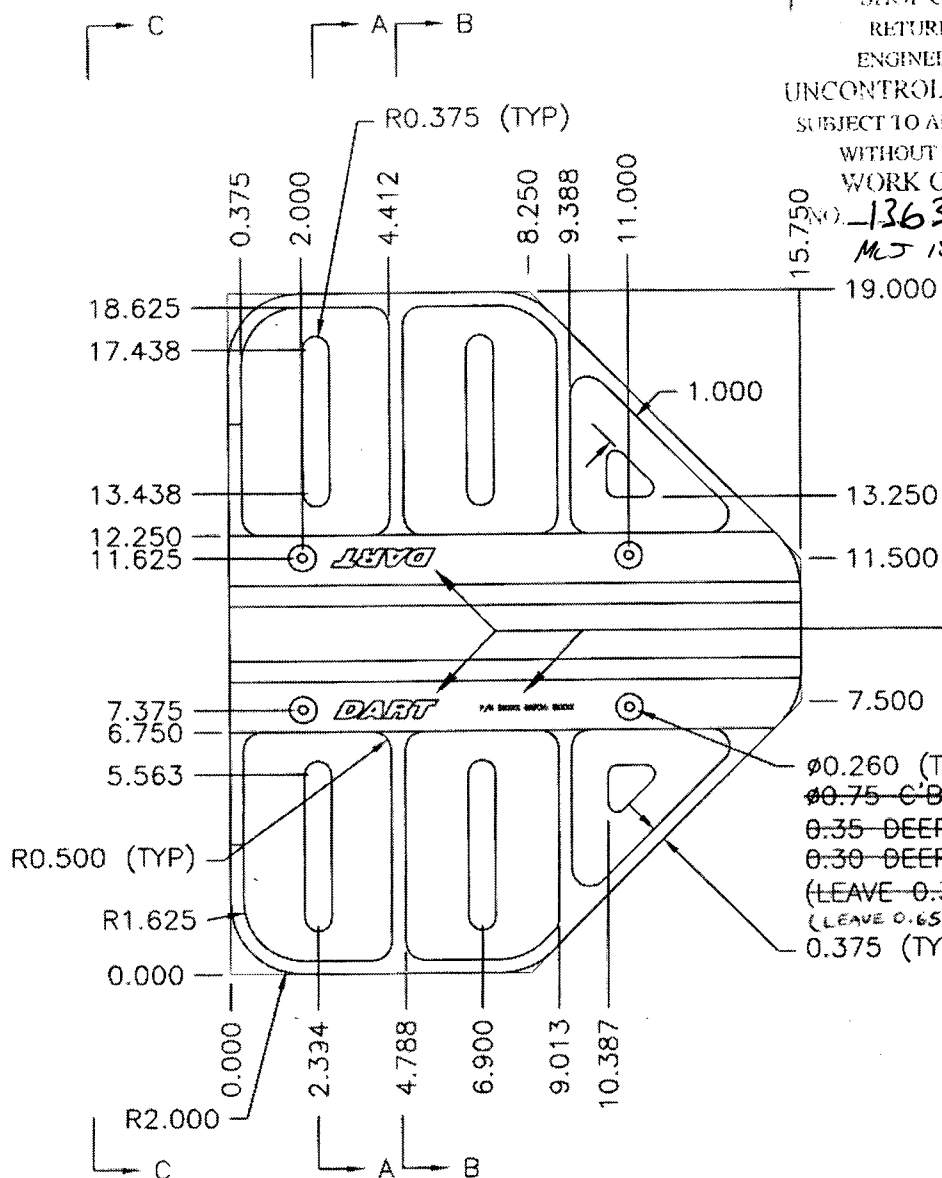


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 136355
MJS 150903

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

RELEASED
49.06.17 KLE

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED KLE	APPROVED KLE	DRAWING NO. D2435	SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

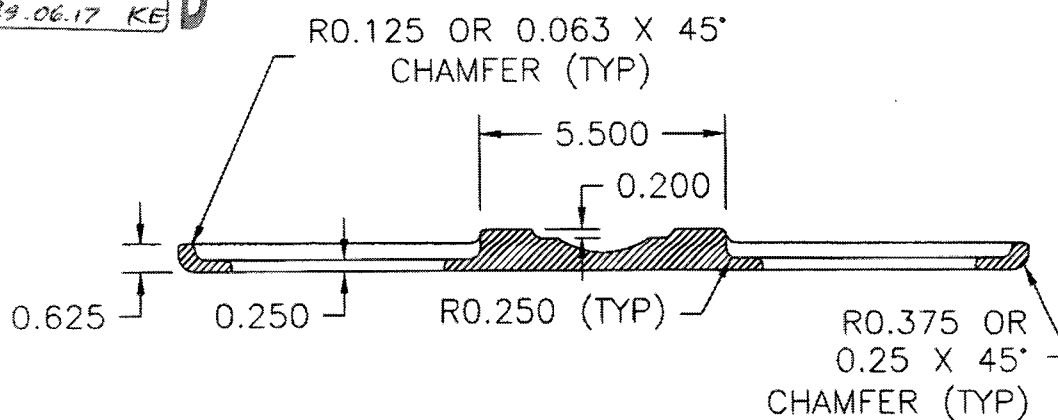
9143

EFFECTIVE DEOS

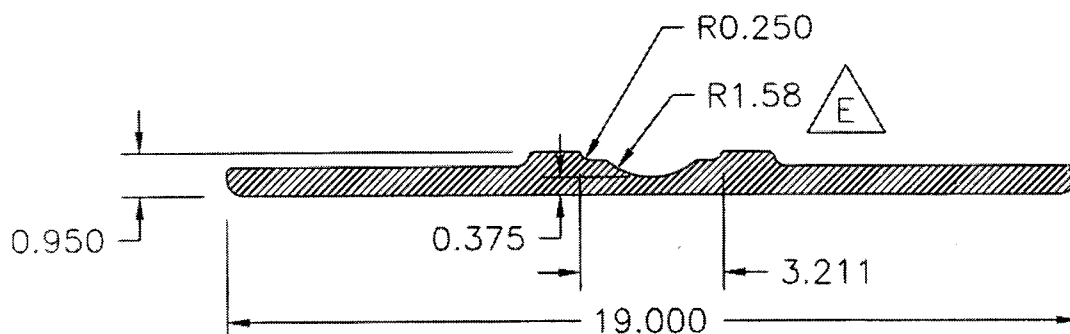


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DIB	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

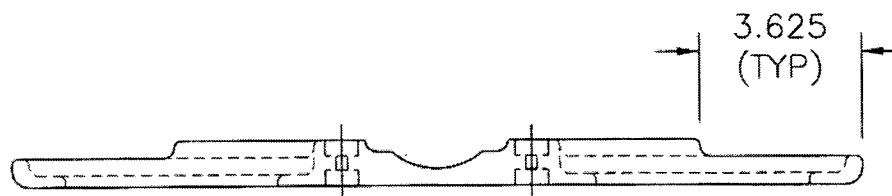
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

REFERENCE ONLY

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-572-011 Bearpaw Installation	8.5 lb 3.86 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	1105 in-lb 12.74 m-kg
D500-572-021 Narrow Bearpaw Installation	7.5 lb 3.41 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	130 in 3.30 m	975 in-lb 11.25 m-kg
D500-572-013 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	128 in 3.25 m	1459 in-lb 16.80 m-kg
D600-572-015 Bearpaw Installation	11.4 lb 5.17 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	122 in 3.10 m	1391 in-lb 16.03 m-kg

5. PARTS LIST

Qty D500 -572 -011	Qty D500 -572 -021	Qty D500 -572 -013	Qty D600 -572 -015	Part Number	Description
X				D500-572-011	BEARPAW INSTALLATION
	X			D500-572-021	NARROW BEARPAW INSTALLATION
		X		D500-572-013	BEARPAW INSTALLATION
			X	D600-572-015	BEARPAW INSTALLATION
2				D2435	BEARPAW
	2			D2671	BEARPAW
		2		D2995	BEARPAW
			2	D2996	BEARPAW
4	4	4		D2182B050	RUBBER CUSHION
			4	D2182B060	RUBBER CUSHION
8	8	8	8	D2274	RADIUS BLOCK
4	4	4		D2438	CLAMP
			4	D2519	CLAMP
8	8	8	8	D2529	WASHER
		8	8	AN4-13A	BOLT
8	8			AN4-15A	BOLT
8	8	8	8	AN960JD416	WASHER
8	8	8	8	MS21042L4	NUT (OR MS21042-4)
2	2			QS200M44S	CLAMP
			4	QS100M24S	CLAMP

• COPYRIGHT © 2001 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: A

Date: 01.02.21